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(54) Title: METHOD OF MAKING HYDROGENATED METATHESIS PRODUCTS

(57) **Abstract:** Disclosed is a method of making hydrogenated metathesis products comprising the steps of: (a) providing a metathesis composition; (b) providing a metathesis catalyst comprising a transition metal; (c) metathesizing at least a portion of the metathesis composition in the presence of the metathesis catalyst to form a first composition comprising one or more metathesis products and a transition metal; (d) hydrogenating at least a portion of the first composition in the presence of a hydrogenation catalyst to form a second composition comprising one or more hydrogenated metathesis products, transition metal, and hydrogenation catalyst; and (e) removing at least a portion of the hydrogenation catalyst from the second composition, wherein the removal of the hydrogenation catalyst removes at least a portion of the transition metal of the metathesis catalyst from the second composition.

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METHOD OF MAKING HYDROGENATED METATHESIS PRODUCTS

CROSS-REFERENCE TO RELATED APPLICATIONS

This application claims priority to US60/757761, filed January 10, 2006, the
5 disclosure of which is incorporated herein by reference in its entirety.

BACKGROUND

Metathesis is a catalytic reaction and involves the interchange of alkylidene units among olefinic hydrocarbons via the formation and cleavage of carbon-carbon double bonds. The metathesis reaction may occur between two of the same type of molecules, 10 referred to as self-metathesis, and/or may occur between two dissimilar types of molecules; referred to as cross-metathesis. Metathesis is a well-known and useful synthetic step in the production of industrial chemicals.

Metathesis reactions are typically catalyzed by transition metal carbene complexes, for example, complexes comprising ruthenium, molybdenum, osmium, chromium, rhenium, 15 or tungsten. Upon completion of the metathesis reaction it is typically desirable to remove at least a portion of the metathesis catalyst from the metathesis products.

In one known method for removing metathesis catalyst, tris-(hydroxymethyl)phosphine (THMP) is added to the metathesis products at a rate of about 25 to 100 mol equivalents THMP per mole of metathesis catalyst. The resulting mixture is 20 then stirred at a temperature of about 60°C to 70°C for about 18 to 24 hours under inert atmosphere (e.g., N₂ gas). Degassed water or methanol (e.g., about 150 mL per L of reaction mixture) is then added and stirred for about 10 minutes. The mixture is then centrifuged to provide phase separation. The THMP complexes with the metathesis catalyst allowing it to be removed by separation of the water or methanol phase.

25 In a variation to this method (see, Maynard and Grubbs, *Tetrahedron* 1999, 40, 4137-4140) triethylamine is added along with THMP to the metathesis products, followed

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by treatment with an excess of silica gel and filtration. A level of 206 ppm Ru in the product is reported.

In another reported method (see, Paquette et. al. *Organic Letters* 2000, 2(9), 1259-1261), 1.5 equivalents of lead tetraacetate is added to the reaction mixture and stirred 5 overnight, followed by filtration through a pad of silica gel. A level of 300 ppm of Ru in the product is reported.

In another reported method (see, Ahn et. al.; *Organic Letters* 2001, 3(9), 1411-1413) 10 50 equivalents of triphenylphosphine oxide or dimethyl sulfoxide is added to the reaction mixture, followed by chromatography on silica gel. A level of 100 ppm Ru in the product is reported.

Other reported methods include the method of Cho and Kim (see, *Organic Letters* 2003, 5(4), 531-533) (reports treatment of the reaction mixture with silica and at least 50 equivalents of carbon, followed by column chromatography on silica gel. A level of 12 ppm Ru in the product is reported.); the method of Westhus et. al. (see, *Tetrahedron Letters* 2004, 15 45, 3141-3142) (reports the use of a polymer-bound chelate phosphine, optionally followed by treatment with silica gel or carbon. A level of 1120 to 2400 ppm is reported.); the method reported in WO 2003/026770 (reports the use of 360 equivalents of activated alumina, followed by filtration through Celite brand activated charcoal. A level of 9 ppm Ru in the final product is reported.); the method of WO 2005/056182 (reports the use of 20 supercritical CO₂ to precipitate the catalyst. A level of 56 ppm Ru in the final product is reported.); and the method reported in WO 2005/075502 (reports the use of dithiothreitol, dithioerythritol, or citric acid, followed by extraction with water and aqueous base, and finally treatment with charcoal. A level of 210 to 310 ppm Ru in the final product is reported.).

25 Often, metathesis is followed by hydrogenation, whereby at least a portion of the double bond(s) that are present in the metathesis products are converted to single bonds.

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When metathesis is followed by hydrogenation, the metathesis catalyst is conventionally removed after the metathesis reaction but before the hydrogenation reaction. Although the removal of catalyst can be accomplished using known methods, the catalyst removal process adds a step to the manufacturing process with an associated material cost, processing cost, 5 and yield loss. What is desired is a method of removing the metathesis catalyst (or the transition metal of the metathesis catalyst) that can be accomplished without adding a processing step to the manufacturing route of a chemical compound.

SUMMARY

The invention provides an improved method of making hydrogenated metathesis 10 products. Advantageously, the method does not require a separate step to remove or reduce the level of transition metal that is present in the hydrogenated metathesis products due to the metathesis catalyst. Although not wishing to be bound by theory, it is believed that the hydrogenation catalyst in some way binds the transition metal or the metathesis catalyst during the hydrogenation reaction. It is also possible that the hydrogenation reaction 15 converts the metathesis catalyst into a form that is more easily removed. Therefore, removal of the hydrogenation catalyst (e.g., by filtration) after hydrogenation results in the removal of at least a portion of the metathesis catalyst transition metal from the hydrogenated metathesis product.

In one embodiment, the method of the invention comprises the steps of:

20 (a) providing a metathesis composition;
(b) providing a metathesis catalyst comprising a transition metal;
(c) metathesizing at least a portion of the metathesis composition in the presence of the metathesis catalyst to form a first composition comprising one or more metathesis products and transition metal;

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- (d) hydrogenating at least a portion of the first composition in the presence of a hydrogenation catalyst to form a second composition comprising one or more hydrogenated metathesis products, transition metal, and hydrogenation catalyst; and
- (e) removing at least a portion of the hydrogenation catalyst from the second

5 composition, wherein the removal of the hydrogenation catalyst removes at least a portion of the transition metal of the metathesis catalyst from the second composition.

Useful starting compositions for metathesis include petroleum or oleochemical-derived compounds having at least one carbon-carbon double bond. Representative oleochemical-derived starting compositions include polyol esters, for example, polyol esters 10 of unsaturated fatty acids. In some embodiments, the metathesis compositions are triacylglycerides, for example, vegetable oils or animal fats. In an exemplary embodiment, the vegetable oil is refined, bleached and deodorized (RBD) soybean oil.

The metathesis reaction is conducted in the presence of a metathesis catalyst comprising a transition metal, for example, ruthenium, molybdenum, osmium, chromium, 15 rhenium, or tungsten. Useful hydrogenation catalysts are known in the art and comprise nickel, copper, palladium, or platinum. In an exemplary embodiment, the hydrogenation catalyst comprises nickel that has been chemically reduced with hydrogen to an active state and provided on a support of silica or alumina or carbon.

In another aspect, the invention provides hydrogenated metathesis products that are 20 prepared from the method of the invention. In some embodiments, the hydrogenated metathesis products contain about 100 ppm or less of the transition metal of the metathesis catalyst (e.g., ruthenium). In other embodiments, the hydrogenated metathesis products contain about 10 ppm or less of the transition metal of the metathesis catalyst. In an exemplary embodiment, the hydrogenated metathesis product contains about 1 ppm or less 25 of the transition metal of the metathesis catalyst.

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The hydrogenated metathesis products may be solid, liquids, oils, or waxes. In an exemplary embodiment, the hydrogenated metathesis products are in the form of a wax comprising hydrogenated metathesized vegetable oil (e.g., soybean oil). The metathesized vegetable oil may be hydrogenated to have an Iodine Value (IV) of about 75 or less, for 5 example, 50 or less or 25 or less.

DETAILED DESCRIPTION

Metathesis Compositions and Products:

Metathesis compositions comprise compounds that contain at least one carbon-carbon double bond that is suitable for a metathesis reaction. Metathesis reactions include, 10 for example, self-metathesis, cross-metathesis, ring-opening metathesis, ring-opening metathesis polymerizations (ROMP), ring-closing metathesis (RCM), and acyclic diene metathesis (ADMET). Examples of metathesis compositions, processes, and products are reported in R. L. Pederson, *Commercial Applications of Ruthenium Metathesis Processes*; in 15 "Handbook of Metathesis"; Vol. 2; R.H. Grubbs Ed.; Wiley-VCH Weinheim, Germany; 2003; pp. 491 to 510 (ISBN No. 3-527-30616-1).

In some embodiments, the metathesis compositions comprise polyol esters of unsaturated fatty acids. The polyol esters typically comprise one or more of monoacylglycerides, diacylglycerides, and triacylglycerides. The polyol esters are derived, 20 for example, from vegetable or animal origin. Representative examples of vegetable oils comprising polyol esters of unsaturated fatty acids include soybean oil (including modified soybeans such as low linolenic varieties), palm oil, palm kernel oil, coconut oil, cocoa butter, corn oil, peanut oil, cottonseed oil, canola oil (including high oleic varieties), sunflower oil (including high oleic varieties), castor oil, safflower oil, tall oil, tung oil, linseed oil, jojoba oil, olive oil, used fry oils from food processing operations, and the like. 25 Representative examples of animal oils include tallow, lard, fish oil, or chicken fat. In an exemplary embodiment, the metathesis composition is refined, bleached, and deodorized

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(i.e., RBD) soybean oil. The metathesis compositions may include esters of the fatty acids provided by the oils and fats and molecules with a single hydroxy site such as fatty acid methyl esters.

As used herein, "polyol esters" refers to esters produced from polyols. Polyols may 5 include more than two hydroxyl groups. These polyols may comprise from two to about 10 carbon atoms, and may comprise from two to six hydroxyl groups, but other numbers of carbon atoms and/or hydroxyl groups are possible as well. The polyols may contain two to four hydroxyl moieties. Non-limiting examples of polyols include glycerin, 1,2-propanediol, 1,3-propanediol, 1,2-butanediol, 1,3-butanediol, 2,3-butanediol, 2-ethyl-1,3-propanediol, 2-ethyl-2-butyl-1,3-propanediol, neopentyl glycol, 2,2,4-trimethyl-1,3-pentanediol, trimethylolpropane (TMP), sorbitol and pentaerythritol. Very commonly, the 10 polyol esters employed herein are esters of glycerin, e.g., triacylglycerides, or esters of a mixture of glycerin and one or more other polyols.

The polyol ester component may include a partial fatty acid ester of one or more 15 polyols and/or a polyol which is fully esterified with fatty acids ("complete polyol fatty acid ester"). Examples of complete polyol fatty acid esters include triacylglycerides, propylene glycol diesters and tetra esters of pentaerythritol. Examples of suitable polyol partial esters include fatty acid monoglycerides, fatty acid diglycerides and sorbitan partial esters (e.g., diesters and triesters of sorbitan). In some embodiments, the polyol may include from 2 to 6 20 carbon atoms and 2 to 6 hydroxyl groups. Examples of suitable polyols include glycerol, trimethylolpropane, ethylene glycol, propylene glycol, pentaerythritol, sorbitan and sorbitol.

In some embodiments, the polyol esters are metathesized and hydrogenated to form 25 wax compositions. For example, in one embodiment, refined, bleached and deodorized (RBD) soybean oil is self metathesized in the presence of a metathesis catalyst to form a metathesis product. According to the method of the invention, the resulting metathesis product is then hydrogenated without first removing the metathesis catalyst to form a

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hydrogenated metathesis product in the form of a wax. Subsequent removal of the hydrogenation catalyst results in removal of at least a portion of the transition metal from the metathesis catalyst. Wax compositions comprising hydrogenated metathesis products are described, for example, in PCT Application No. WO 06/076364, titled CANDLE AND

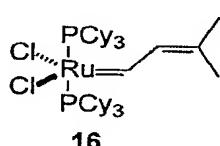
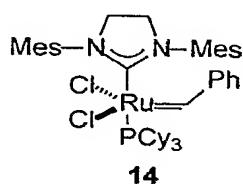
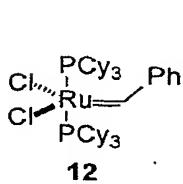
5 CANDLE WAX CONTAINING METATHESIS AND METATHESIS-LIKE PRODUCTS.

In addition to wax products, the method of the invention may be employed to manufacture other products that are obtainable directly or indirectly via metathesis reactions. Representative examples include polymers, industrial chemicals such as additives (e.g., mono and dicarboxylic acids, surfactants, and solvents) and lubricants, fine chemicals 10 (e.g., insect pheromones, carotenoids, and pharmaceutical intermediates), active pharmaceutical ingredients, agricultural chemicals (e.g., pesticides and herbicides), and the like.

Metathesis Catalysts:

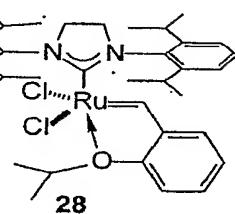
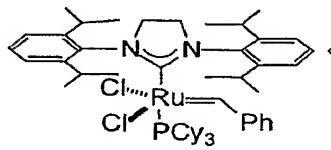
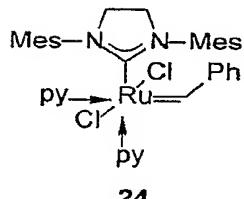
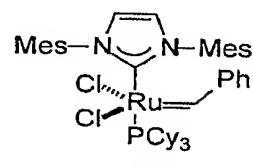
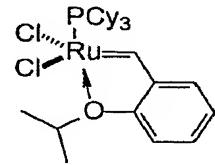
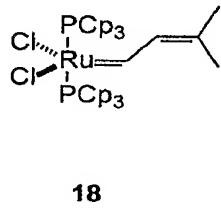
The metathesis reaction is conducted in the presence of a catalytically effective 15 amount of a metathesis catalyst. The term "metathesis catalyst" includes any catalyst or catalyst system which catalyzes the metathesis reaction.

Any known or future-developed metathesis catalyst may be used, alone or in combination with one or more additional catalysts. Exemplary metathesis catalysts include metal carbene catalysts based upon transition metals, for example, ruthenium, molybdenum, 20 osmium, chromium, rhenium, and tungsten. Exemplary ruthenium-based metathesis catalysts include those represented by structures 12 (commonly known as Grubbs's catalyst), 14 and 16, where Ph is phenyl, Mes is mesityl, and Cy is cyclohexyl.



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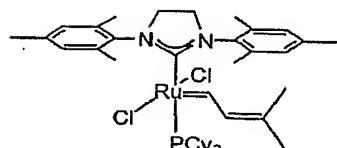
Structures 18, 20, 22, 24, 26, and 28, illustrated below, represent additional ruthenium-based metathesis catalysts, where Ph is phenyl, Mes is mesityl, py is pyridine, Cp is cyclopentyl, and Cy is cyclohexyl. Techniques for using catalysts 12, 14, 16, 18, 20, 22, 24, 26, and 28, as well as additional related metathesis catalysts, are known in the art.



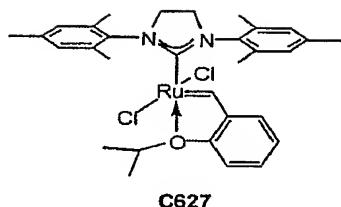
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Catalysts C627, C682, C697, C712, and C827 are additional ruthenium-based catalysts, where Cy is cyclohexyl in C827.

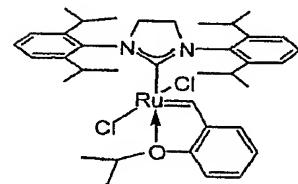
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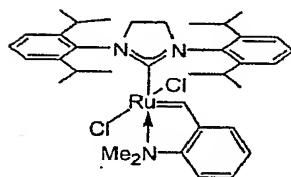
C827



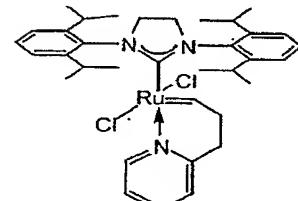
C627



C712



C697



C682

Additional exemplary metathesis catalysts include, without limitation, metal carbene complexes selected from the group consisting of molybdenum, osmium, chromium, rhenium, and tungsten. The term "complex" refers to a metal atom, such as a transition metal atom, with at least one ligand or complexing agent coordinated or bound thereto. Such a ligand typically is a Lewis base in metal carbene complexes useful for alkyne or alkene-metathesis. Typical examples of such ligands include phosphines, halides and stabilized carbenes. Some metathesis catalysts may employ plural metals or metal co-catalysts (e.g., a catalyst comprising a tungsten halide, a tetraalkyl tin compound, and an organoaluminum compound).

An immobilized catalyst can be used for the metathesis process. An immobilized catalyst is a system comprising a catalyst and a support, the catalyst associated with the support. Exemplary associations between the catalyst and the support may occur by way of chemical bonds or weak interactions (e.g. hydrogen bonds, donor acceptor interactions)

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between the catalyst, or any portions thereof, and the support or any portions thereof.

Support is intended to include any material suitable to support the catalyst. Typically, immobilized catalysts are solid phase catalysts that act on liquid or gas phase reactants and products. Exemplary supports are polymers, silica or alumina. Such an immobilized

5 catalyst may be used in a flow process. An immobilized catalyst can simplify purification of products and recovery of the catalyst so that recycling the catalyst may be more convenient.

The metathesis process can be conducted under any conditions adequate to produce the desired metathesis products. For example, stoichiometry, atmosphere, solvent, 10 temperature and pressure can be selected to produce a desired product and to minimize undesirable byproducts. The metathesis process may be conducted under an inert atmosphere. Similarly, if the olefin reagent is supplied as a gas, an inert gaseous diluent can be used. The inert atmosphere or inert gaseous diluent typically is an inert gas, meaning that the gas does not interact with the metathesis catalyst to substantially impede catalysis. For 15 example, particular inert gases are selected from the group consisting of helium, neon, argon, nitrogen and combinations thereof.

Similarly, if a solvent is used, the solvent chosen may be selected to be substantially inert with respect to the metathesis catalyst. For example, substantially inert solvents include, without limitation, aromatic hydrocarbons, such as benzene, toluene, xylenes, etc.; 20 halogenated aromatic hydrocarbons, such as chlorobenzene and dichlorobenzene; aliphatic solvents, including pentane, hexane, heptane, cyclohexane, etc.; and chlorinated alkanes, such as dichloromethane, chloroform, dichloroethane, etc.

In certain embodiments, a ligand may be added to the metathesis reaction mixture. In many embodiments using a ligand, the ligand is selected to be a molecule that stabilizes 25 the catalyst, and may thus provide an increased turnover number for the catalyst. In some cases the ligand can alter reaction selectivity and product distribution. Examples of ligands

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that can be used include Lewis base ligands, such as, without limitation, trialkylphosphines, for example tricyclohexylphosphine and tributyl phosphine; triarylphosphines, such as triphenylphosphine; diarylalkylphosphines, such as, diphenylcyclohexylphosphine; pyridines, such as 2,6-dimethylpyridine, 2,4,6-trimethylpyridine; as well as other Lewis 5 basic ligands, such as phosphine oxides and phosphinites. Additives may also be present during metathesis that increase catalyst lifetime.

Any useful amount of the selected metathesis catalyst can be used in the process. For example, the molar ratio of the unsaturated polyol ester to catalyst may range from about 5:1 to about 10,000,000:1 or from about 50:1 to 500,000:1.

10 The metathesis reaction temperature may be a rate-controlling variable where the temperature is selected to provide a desired product at an acceptable rate. The metathesis temperature may be greater than -40°C, may be greater than about -20°C, and is typically greater than about 0°C or greater than about 20°C. Typically, the metathesis reaction temperature is less than about 150°C, typically less than about 120°C. An exemplary 15 temperature range for the metathesis reaction ranges from about 20°C to about 120°C.

The metathesis reaction can be run under any desired pressure. The total pressure may be selected to be greater than about 10kPa, in some embodiments greater than about 30 kPa, or greater than about 100kPa. Typically, the reaction pressure is no more than about 7000 kPa, in some embodiments no more than about 3000 kPa. An exemplary pressure 20 range for the metathesis reaction is from about 100 kPa to about 3000 kPa.

In some embodiments, the metathesis reaction is catalyzed by a system containing both a transition and a non-transition metal component. The most active and largest number of catalyst systems are derived from Group VI A transition metals, for example, tungsten and molybdenum.

25 Hydrogenation Catalysts:

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In some embodiments, the method of the invention utilizes hydrogenation catalysts comprising, for example, nickel, copper, palladium, platinum, molybdenum, iron, ruthenium, osmium, rhodium, or iridium. Combinations of metals may also be used. Useful catalyst may be heterogeneous or homogeneous. In some embodiments, the catalysts are 5 supported nickel or sponge nickel type catalysts.

In some embodiments, the hydrogenation catalyst comprises nickel that has been chemically reduced with hydrogen to an active state (i.e., reduced nickel) provided on a support. In some embodiments, the support comprises porous silica (e.g., kieselguhr, 10 infusorial, diatomaceous, or siliceous earth) or alumina. The catalyst are characterized by a high nickel surface area per gram of nickel.

In some embodiments, the particles of supported nickel catalyst are dispersed in a protective medium comprising hardened triacylglyceride, edible oil, or tallow. In an exemplary embodiment, the supported nickel catalyst is dispersed in the protective medium at a level of about 22 wt.% nickel.

15 In some embodiments, the supported nickel catalysts are of the type reported in U.S. Patent No. 3,351,566 (Taylor et al.). These catalyst comprise solid nickel-silica having a stabilized high nickel surface area of 45 to 60 sq. meters per gram and a total surface area of 225 to 300 sq. meters per gram. The catalysts are prepared by precipitating the nickel and silicate ions from solution such as nickel hydrosilicate onto porous silica particles in such 20 proportions that the activated catalyst contains 25 to 50 wt.% nickel and a total silica content of 30 to 90 wt%. The particles are activated by calcining in air at 600 to 900 F, then reducing with hydrogen.

Useful catalysts having a high nickel content are described in EP 0 168 091, wherein the catalyst is made by precipitation of a nickel compound. A soluble aluminum 25 compound is added to the slurry of the precipitated nickel compound while the precipitate is maturing. After reduction of the resultant catalyst precursor, the reduced catalyst typically

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has a nickel surface area of the order of 90 to 150 sq. m per gram of total nickel. The catalysts have a nickel/aluminum atomic ratio in the range of 2 to 10 and have a total nickel content of more than about 66% by weight.

Useful high activity nickel/alumina/silica catalysts are described in EP 0 167 201.

5 The reduced catalysts have a high nickel surface area per gram of total nickel in the catalyst.

Useful nickel/silica hydrogenation catalysts are described in U.S. Patent No.

6,846,772. The catalysts are produced by heating a slurry of particulate silica (e.g. kieselguhr) in an aqueous nickel amine carbonate solution for a total period of at least 200 minutes at a pH above 7.5, followed by filtration, washing, drying, and optionally

10 calcination. The nickel/silica hydrogenation catalysts are reported to have improved filtration properties.

Also useful are high surface area nickel/alumina hydrogenation catalysts, for example as reported in U.S. Patent No. 4,490,480. These catalysts typically have a total nickel content of 5 to 40% by weight.

15 Commercial examples of supported nickel hydrogenation catalysts include those available under the trade designations "NYSOFAC", "NYSOSEL", and "NI 5248 D" (from Englehard Corporation, Iselin, NH). Additional supported nickel hydrogenation catalysts include those commercially available under the trade designations "PRICAT 9910", "PRICAT 9920", "PRICAT 9908", "PRICAT 9936, and "PRICAT 9925" (from

20 Johnson Matthey Catalysts, Ward Hill, MA).

Hydrogenation may be carried out in a batch or in a continuous process and may be partial hydrogenation or complete hydrogenation. In a representative batch process, a vacuum is pulled on the headspace of a stirred reaction vessel and the reaction vessel is charged with soybean oil (e.g., RBD soybean oil). The soybean oil may be heated to a

25 desired temperature. Typically, the temperature ranges from about 50° C to 350° C, for example, about 100° C to 300° C or about 150° C to 250° C. The desired temperature may

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vary, for example, with hydrogen gas pressure. Typically, a higher gas pressure will require a lower temperature. In a separate container, the hydrogenation catalyst is weighed into a mixing vessel and is slurried with a small amount of soybean oil. When the soybean oil reaches the desired temperature, the slurry of hydrogenation catalyst is added to the reaction 5 vessel. Hydrogen gas is then pumped into the reaction vessel to achieve a desired pressure of H₂ gas. Typically, the H₂ gas pressure ranges from about 15 to 3000 psig, for example, about 40 to about 100 psig. As the gas pressure increases, more specialized high-pressure processing equipment may be required. Under these conditions the hydrogenation reaction begins and the temperature is allowed to increase to the desired hydrogenation temperature, 10 where it is maintained by cooling the reaction mass, for example, with cooling coils. Typically, the hydrogenation temperature ranges from about 20° C to about 250° C, for example, about 100° C or greater, or about 120° C to about 220° C. When the desired degree of hydrogenation is reached, the reaction mass is cooled to the desired filtration temperature.

15 The amount of hydrogenation catalysts is typically selected in view of a number of factors including, for example, the type of hydrogenation catalyst used, the amount of hydrogenation catalyst used, the degree of unsaturation in the metathesis product, the desired rate of hydrogenation, the desired degree of hydrogenation (e.g., as measure by iodine value (IV)), the purity of the reagent, and the H₂ gas pressure. In some embodiments, 20 the hydrogenation catalyst is used in an amount of about 10 wt.% or less, for example, about 5 wt.% or less or about 1 wt.% or less.

Hydrogenation Catalyst Removal Process:

After hydrogenation, the used hydrogenation catalyst is removed from the hydrogenated metathesized product using known techniques such as filtration. In some 25 embodiments, the hydrogenation catalyst is removed using a plate and frame filter such as those commercially available from Sparkle Filters, Inc., Conroe TX. In some embodiments,

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the filtration is performed with the assistance of pressure or a vacuum. In order to improve filtering performance, a filter aid may be used. A filter aid may be added to the metathesized product directly or it may be applied to the filter. Representative examples of filtering aids include diatomaceous earth, silica, alumina, and carbon. Typically, the 5 filtering aid is used in an amount of about 10 wt.% or less, for example, about 5 wt.% or less or about 1 wt.% or less. Other filtering techniques and filtering aids may also be employed to remove the used hydrogenation catalyst. In other embodiments the hydrogenation catalyst is removed using centrifugation followed by decantation of the product.

After filtering, the hydrogenated metathesis products typically contains less than 10 about 100 ppm of the metathesis catalyst transition metal. In other embodiments, the hydrogenated metathesis products contain less than about 10 ppm of the metathesis catalyst transition metal. In still other embodiments, the hydrogenated metathesis products contain less than about 1 ppm of the metathesis catalyst transition metal, for example, about 0.9 ppm or less, about 0.8 ppm or less, about 0.7 ppm or less, about 0.6 ppm or less, about 0.5 ppm 15 or less, about 0.4 ppm or less, about 0.3 ppm or less, or about 0.1 ppm or less. In exemplary embodiments, the metathesis catalyst is a ruthenium-based catalyst and the hydrogenated metathesis product contains less than about 0.1 ppm ruthenium.

The following examples are presented to illustrate the present invention and to assist one of ordinary skill in making and using the same. The examples are not intended in any 20 way to limit the scope of the invention.

EXAMPLES

Example 1:

RBD soybean oil (~780 kg) was charged to an agitated 2600L vessel. The vessel and soybean oil were then sparged with Ar gas overnight. The soybean oil was then heated 25 to a temperature of 70° C and 39 grams (50 ppm) of C827 ruthenium metathesis catalyst was added to the soybean oil to initiate the metathesis reaction. The agitated vessel was

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operated with a slight head pressure (~2 psig) of Ar gas. The metathesis reaction was allowed to proceed for two hours. Following this, the metathesized oil was held in the vessel for an additional 4-5 hours. Following this, the metathesized oil was transferred to an agitated holding tank in preparation for hydrogenation. The metathesized oil was then split 5 into four approximately equal batches for hydrogenation in order to accommodate the 300L agitated, pressure-rated vessel that was available. A loading of 0.4 wt% Ni hydrogenation catalyst (Pricat 9925, from Johnson Matthey) was used for all batches. The reaction conditions for the four hydrogenation batches are summarized in Table 1.

TABLE 1

<u>Batch</u>	<u>Batch size</u>	<u>Temperature</u>	<u>H₂ pressure</u>	<u>Reaction time</u>
1	194 kg	210 °C	50 psig	4.0 hr
2	193 kg	175 °C	90 psig	4.0 hr
3	193 kg	185 °C	90 psig	2.3 hr
4	180 kg	185 °C	90 psig	2.7 hr

10

The four hydrogenation products were combined in the 2600L agitated tank in advance of filtration. The combined hydrogenated metathesized oil was held at 70°C. Citric acid (0.1 wt%), bleaching clay (2.0 wt%), and filter aid (0.1 wt%) were mixed with the oil before passing through a plate and frame filter (4 x 2" frames). A second pass was 15 required due to breakage of one of the filter papers in the first pass. After filtration, 675 kg of hydrogenated metathesized soybean oil was recovered.

Example 2:

18,300 pounds of RBD soybean oil (Cargill) was transferred from a tank into a nitrogen purged reaction vessel. Separately, 415 grams (50 ppm catalyst for the final 20 reaction mixture) of C827 metathesis catalyst was slurried in about 4 gallons of soybean oil. The resulting slurry was added to the soybean oil in the reaction vessel which was held at a temperature of 70°C. The reaction mixture was then held in the reaction vessel for a period

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of about 3 hours. GC analysis of samples of the reaction mixture showed that the reaction mixture reached equilibrium about 30 minutes after addition of the metathesis catalyst.

Next, 27.5 pounds (12.5 kg) of hydrogenation catalyst (PRICAT 9925 from Johnson Matthey) was charged to the vessel. Following addition of the catalyst, the head space in 5 the vessel was charged with H₂ gas. During this time, the reaction mixture was heated to 120°C. When the temperature reached 120°C, the H₂ gas in the head space was increased to a pressure of 50 psig. The heat of the exothermic reaction was used to raise the temperature of the reaction mixture to 185°C. H₂ charging continued for an additional 3 hours. The final IV for the metathesized soybean oil was less than 1.

10 In the same reaction vessel a steady sparge of steam was introduced to remove the more volatile components by steam stripping. The vessel was cooled during stripping to 120°C. The resulting product was filtered at 120°C by recirculating the product through a plate and frame filter (Sparkler, Conroe, TX) with a pre-coat of about 25 pounds of diatomaceous earth filter aid ("CELATOM FW-14" from EaglePicher Filtration, Reno, 15 NV). The final Ru content was less than 0.07 ppm Ru.

Example 3:

15,900 pounds of RBD soybean oil (Cargill) was loaded into a reaction vessel. The soybean oil was agitated and was sparged with N₂ gas for 2.5 hours at a rate of 50 SCFH. Separately, 361 grams (50 ppm of catalyst in the final reaction mixture) of C827 metathesis 20 catalyst was slurried in about 3 gallons of soybean oil. The resulting slurry was added to the soybean oil in the reaction vessel. Following addition of the catalyst, the head space in the vessel was evacuated and purged with N₂ gas a total of 3 times over a period of 1 hour. During this time, the reaction mixture was heated to 71°C. The reaction mixture was then held in the reaction vessel for a period of about 3 hours during which the temperature rose to 25 76°C. GC analysis of samples of the reaction mixture showed that the reaction mixture reached equilibrium about 30 minutes after addition of the metathesis catalyst.

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Next, 35.0 pounds (15.9 kg) of hydrogenation catalyst (PRICAT 9925 from Johnson Matthey) was charged to the vessel. . Following addition of the catalyst, the head space in the vessel was evacuated and purged with N₂ gas a total of 3 times over a period of 1 hour. During this time, the reaction mixture was heated to 130°C. When the temperature reached 5 130°C, H₂ gas was charged to the vessel. Thirty minutes into hydrogenation the reaction mixture reached a temperature of 180°C and the flow of hydrogen was stopped for a period of about 75 minutes. After this, the H₂ charging resumed for an additional 3 hours during which the temperature ranged between 172°C and 194°C. The resulting hydrogenated metathesized soybean oil was cooled to a temperature of 84°C and excess H₂ was vented off. 10 The oil was held at about 5 to 8 psig for about 9.5 hours before filtering.

The resulting product was filtered by recirculating the product through a plate and frame filter (Sparker, Conroe, TX) with a pre-coat of about 25 pounds of diatomaceous earth filter aid ("CELATOM FW-14" from EaglePicher Filtration, Reno, NV). The product was recirculated through the filter for about 13 hours total. Twice during the filtration, the filter 15 was taken apart for cleaning and was conditioned with about 25 pounds of filter aid. During filtration, the product was at a temperature of about 90°C or less. The final Ru content was less than 0.1 ppm.

Example 4:

RBD soybean oil (SBO) was used to prepare metathesized soybean oil. 1500 g of 20 SBO was charged into a 2000 ml Parr reactor. After sealing the Parr reactor, the solution in the reactor was degassed with pressurized N₂ (50-100 psi) by pressurizing and releasing N₂ gas for 5 cycles. After degassing, 80 mg of C827 metathesis catalyst dissolved in 2 ml CH₂Cl₂ was added to the Parr reactor and the resulting solution was degassed again using N₂ gas for 3 cycles. Next, the solution in the Parr reactor was heated to 70°C while mixing at 25 300 rpm. When the temperature reached 70°C, the mixing rate was increased to 500 rpm and the self-metathesis reaction was allowed to proceed at 70°C for 3 hours. Following this,

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the solution in the Parr reactor was allowed to cool to room temperature. The Ru content of the solution was measured using ICP.

General Procedure for Hydrogenation:

For each trial identified in TABLE 2 the following general procedure was followed.

5 200 g of metathesized SBO (prepared as described above) and the amount of Ni catalyst (PRICAT 9925 from Johnson Matthey) designated in TABLE 2 were charged to a 600 ml Parr reactor. After sealing the Parr reactor, the resulting composition was heated to 80°C and was degassed with pressurized N₂ (50-100 psi, for the control experiment without using H₂ in the hydrogenation reaction) or pressurized H₂ (50-100 psi) by pressuring and releasing
10 the gas from the Parr reactor for 5 cycles. After degassing, the Parr reactor was pressurized to 100 psi with H₂ gas, except for the control experiment in which neither hydrogen nor another gases was used. Then, the composition in the Parr reactor was heated to the desired temperature (see, TABLE 2) while be mixed at 300 rpm. When the desired temperature was reached, a sample of the composition was taken and the sample was filtered at reduced
15 pressure. The filtered composition was analyzed for Ru and Ni levels using ICP. For each trial, this sample was designated as the time 0 (zero) sample. After taking the sample, the composition in the Parr reactor was mixed at 500 rpm while maintaining the desired temperature for 4 hours. Following this, a sample was taken and the sample was filtered at reduced pressure. The filtered sample was analyzed for Ru and Ni levels using ICP. For
20 each trial, this sample was designated as the 4 hour sample.

The hydrogenation conditions and Ru and Ni levels are provided in TABLE 2. Two hydrogen pressures (0 and 100 psi), three reaction temperatures (100, 190 and 250°C) and two levels of the Ni catalyst (0.1 and 0.5%) were investigated in the hydrogenation experiments. The results are presented in TABLE 2.

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TABLE 2

Exp	Time (hr)	Metathesized SBO		Hydrogenation Conditions				HMSBO	
		Ru* (ppm)	Ni* (ppm)	H ₂ (psi)	Temp (°C)	Ni Cat (%)	Reaction Time (hr)	Ru (ppm)	Ni (ppm)
A0	0	6.8	1.8	0	190	0.5	0.0	6.2	10.0
A4	4	6.8	1.8	0	190	0.5	4.0	5.9	13.5
B0	0	6.8	1.8	100	190	0.5	0.0	5.2	16.3
B4	4	6.8	1.8	100	190	0.5	4.0	0.3	2.8
C0	0	6.8	1.8	100	190	0.1	0.0	6.6	7.6
C4	4	6.8	1.8	100	190	0.1	4.0	0.6	3.3
D0	0	6.8	1.8	100	250	0.5	0.0	0.4	4.6
D4	4	6.8	1.8	100	250	0.5	4.0	0.2	16.0**
E0	0	6.8	1.8	100	100	0.5	0.0	6.4	4.4
E4	4	6.8	1.8	100	100	0.5	4.0	6.7	5.9

*The Ru content in the metathesized SBO is 6.8 ppm and the Ni content (1.8 ppm) comes from the contamination of the previous hydrogenation experiments that were conducted in 5 the same Parr reactor.

**The high Ni content (16.0 ppm) in the product solution at 250°C may be due to a higher solubility of Ni in the product solution.

Observations:

The data shows that the hydrogen pressure, reaction temperature, and the amount of 10 Ni catalyst are factors that contribute to Ru metal absorption and removal from the hydrogenated metathesized soybean oil (HMSBO) using the method of the invention. As shown in trials A0 and A4, the process is not effective without hydrogen gas being present. When other conditions were held constant, a higher hydrogenation temperature resulted in a decrease in Ru metal in the HMSBO. For example, 6.7 ppm Ru was obtained at 100°C 15 (E4); 0.3 ppm was obtained at 190°C (B4); and 0.2 ppm Ru was obtained at 250°C (D4). When other conditions were held constant, an increase in the amount of Ni hydrogenation

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catalyst from 0.1% to 0.5% resulted in a decrease in the Ru content in the HMSBO from 0.6 ppm to 0.3 ppm (see, C4 and B4). The reaction time also influences the Ru removal. The Ru content remained at almost the same as the initial level at the time zero for all the experiments (Exp A0, B0, C0 and E0) except for the trial (Exp D0) at 250°C.

5 All publications and patents mentioned herein are hereby incorporated by reference.

The publications and patents disclosed herein are provided solely for their disclosure.

Nothing herein is to be construed as an admission that the inventors are not entitled to antedate any publication and/or patent, including any publication and/or patent cited herein.

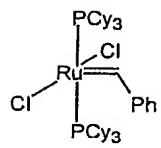
Other embodiments of this invention will be apparent to those skilled in the art upon 10 consideration of this specification or from practice of the invention disclosed herein.

Various omissions, modifications, and changes to the principles and embodiments described herein may be made by one skilled in the art without departing from the true scope and spirit of the invention which is indicated by the following embodiments.

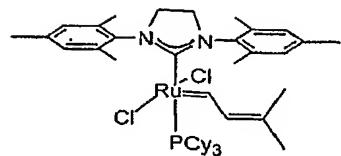
WHAT IS CLAIMED IS:

1. A method of making hydrogenated metathesis products comprising the steps of:
 - (a) providing a metathesis composition;
 - (b) providing a metathesis catalyst comprising a transition metal;
 - 5 (c) metathesizing at least a portion of the metathesis composition in the presence of the metathesis catalyst to form a first composition comprising one or more metathesis products and a transition metal;
 - (d) hydrogenating at least a portion of the first composition in the presence of a hydrogenation catalyst to form a second composition comprising one or more hydrogenated 10 metathesis products, transition metal, and hydrogenation catalyst; and
 - (e) removing at least a portion of the hydrogenation catalyst from the second composition, wherein the removal of the hydrogenation catalyst removes at least a portion of the transition metal of the metathesis catalyst from the second composition.
2. The method of claim 1, wherein the metathesis composition is a polyol ester.
- 15 3. The method of claim 2, wherein the metathesis composition is a triacylglyceride.
4. The method of claim 3, wherein the metathesis composition is a vegetable oil
5. The method of claim 4, wherein the vegetable oil is soybean oil.
6. The method of claim 1, wherein the metathesis catalyst is a metal carbene catalyst based upon a transition metal.
- 20 7. The method of claim 6, wherein the transition metal is ruthenium, molybdenum, osmium, chromium, rhenium, or tungsten.
8. The method of claim 7, wherein the transition metal is ruthenium.
9. The method of claim 8, wherein the metathesis catalyst is selected from the group of:

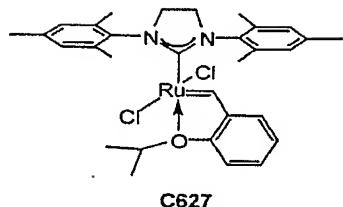
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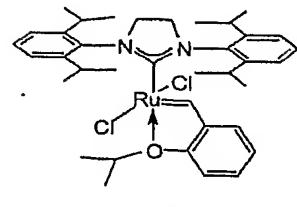
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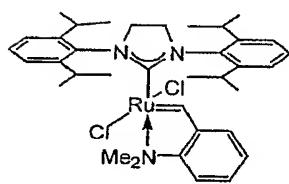
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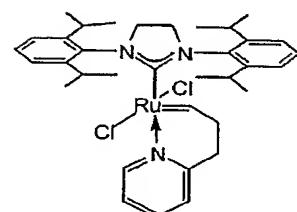
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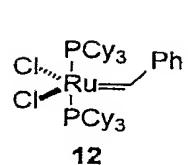
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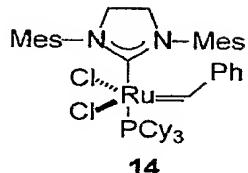
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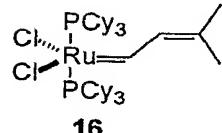
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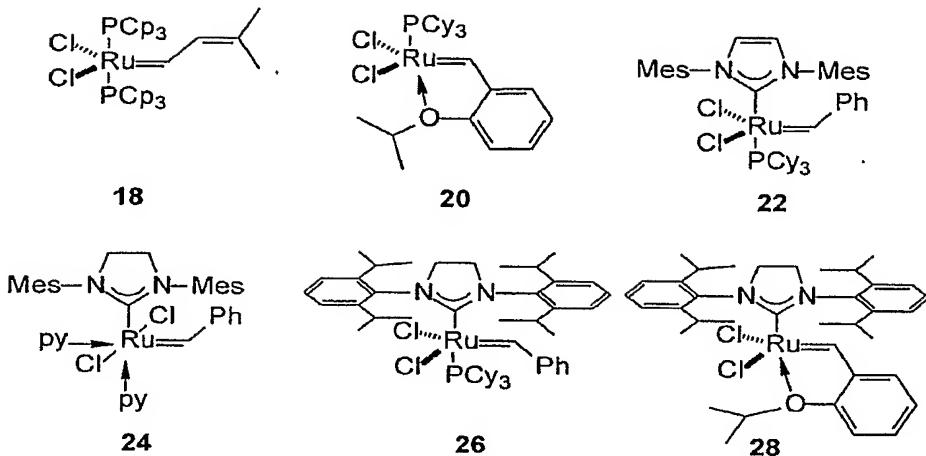


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where Ph is phenyl, Mes is mesityl, py is pyridine, Cp is cyclopentyl, and Cy is cyclohexyl.

10. The method of claim 1, wherein the hydrogenation catalyst is a homogeneous catalyst.

5 11. The method of claim 1, wherein the hydrogenation catalyst is a heterogeneous catalyst.

12. The method of claim 1, wherein the hydrogenation catalyst comprises nickel, copper, palladium, or platinum.

13. The method of claim 12, wherein the hydrogenation catalyst comprises nickel, 10 copper, palladium, or platinum on a silica support.

14. The method of claim 12, wherein the hydrogenation catalyst comprises nickel, copper, palladium, or platinum on an alumina support.

15. The method of claim 12, wherein the hydrogenation catalyst comprises nickel, copper, palladium, or platinum on an alumina/silica support.

16. The method of claim 12, wherein the hydrogenation catalyst comprises nickel, copper, palladium, or platinum on a carbon support.

17. The method of claim 1, wherein the hydrogenated metathesis products contains about 100 ppm or less of the metathesis catalyst transition metal.

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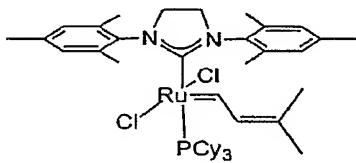
18. The method of claim 1, wherein the hydrogenated metathesis products contains about 10 ppm or less of the metathesis catalyst transition metal.

19. The method of claim 1, wherein the hydrogenated metathesis product contains about 1 ppm or less of the metathesis catalyst transition metal.

5 20. The method of claim 1, wherein the hydrogenated metathesis product contains about 0.1 ppm or less of the metathesis catalyst transition metal.

21. The method of claim 1, wherein the metathesis is self-metathesis, cross-metathesis, ring-opening metathesis, ring-opening metathesis polymerizations (ROMP), ring-closing metathesis (RCM), or acyclic diene metathesis (ADMET).

10 22. The method of claim 1, wherein the metathesis catalyst is



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where Cy is cyclohexyl.

23. The method of claim 1, wherein the hydrogenated metathesis product comprises a wax.

15 24. The method of claim 1, wherein the hydrogenated metathesis product is partially hydrogenated.

25. The method of claim 1, wherein the hydrogenated metathesis product is fully hydrogenated.

26. The method of claim 1, wherein the hydrogenation step is conducted at a 20 temperature of about 20° C to about 250° C.

27. The method of claim 1, wherein the hydrogenation step is conducted at a temperature of about 120° C to 220° C.

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28. The method of claim 1, wherein the hydrogenation step is conducted at a hydrogen pressure of about 15 to about 3000 psig.
29. The method of claim 1, wherein the hydrogenation step is conducted at a hydrogen gas pressure of about 40 to about 100 psig.
- 5 30. A hydrogenated metathesis product prepared by the method of claim 1.
31. The hydrogenated metathesis product of claim 30, wherein the hydrogenated metathesis product contains about 10 ppm or less of the metathesis catalyst transition metal.
32. The hydrogenated metathesis product of claim 30, wherein the hydrogenated .. metathesis product contains about 1 ppm or less of the metathesis catalyst transition metal.
- 10 33. A hydrogenated metathesis product comprising less than about 1 ppm of metathesis catalyst transition metal.